

Date: Monday, 11/08/2008 2:45:35 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE
Job Number	: 41128	Part Number	: D29321
Estimate Number	: 10831	Drawing Number	: D2932 REV C
P.O. Number	:	Project Number	: N/A
This Issue	: 11/08/2008 S.O. No. : /	Drawing Revision	: C
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : MACHINED PARTS	Due Date	: 12/09/2008 Qty: 6 Um: Each
Previous Run	: 39887		
Written By	:		
Checked & Approved By	: JLD 08.8.11		
Comment	: Est: B 00.06.26 New DWG rev, (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	Saddle Billet, 7075
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock:

7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length

Batch No: B33792

JLD 08/08/30

⑥

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr & TUMBLE

J.F. / JLD 08/08/30

⑥

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

JLD 08/08/30

⑥

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

JLD 08/08/30

⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/08/2008 2:45:35 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 41128

Part Number: D29321

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



(6)



Comment: SECOND CHECK

JTP 08/08/30

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(6)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/09/02

7.0

POWDER COATING

POWDER COATING



M 108523



(6X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

10:40

OVEN TEMPERATURE:

320°F

FINISH TIME:

11:10

M-L 08/09/02

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(6)

Comment: INSPECT POWDER COAT

FL 08/09/02

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(6X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 428

8/9/02

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 41120
Description: 206 Saddle, Outboard, Left side	Part Number: D2932-1
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.124"	.114	.116	.115		
B	0.100	0.140		.123"	.116	.116	.173		
C	0.100	0.140		.120"	.115	.116	.117		
D	0.210	0.230		.220"	.218	.222	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.516	.510	.510	.510		
I	1.572	1.582		1.578"	1.577	1.578	1.578		
J	2.495	2.505		2.500	2.499	2.498	2.499		
K	0.257	0.262		0.258"	.259	.259	.259		
L	0.312	0.317		0.313"	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.120"	.123	.123	.123		
O	0.540	0.560		.547"	.546	.546	.544		
P	0.490	0.510		.503	.503	.502	.505		
Q	3.715	3.725		3.720"	3.722	3.719	3.719		
R	2.470	2.510		2.493"	2.490	2.493	2.491		
S	0.240	0.270		.250"	.249	.248	.248		
T	0.100	0.180		.140"	.140	.140	.140		
U	1.625	1.635		1.631"	1.626	1.629	1.629		
V	1.362	1.372		1.369"	1.365	1.366	1.366		
W	0.316	0.321		0.320"	.320	.320	.320		
X	1.125	1.145		1.134"	1.135	1.135	1.135		
Y	1.565	1.585		1.573"	1.574	1.574	1.574		
Z	0.178	0.198		.188"	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.F. / JMF
Date:	08/08/30

Audited by:	DJP
Date:	08/08/30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD		Work Order: 41128
Description: 206 Saddle, Outboard, Left side		Part Number: D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.116	.116				
B	0.100	0.140		.116	.116				
C	0.100	0.140		.115	.117				
D	0.210	0.230		.221	.222				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.256	1.250				
G	2.495	2.505		2.506	2.506				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.499	2.499				
K	0.257	0.262		.259	.251				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.121	.122				
O	0.540	0.560		.544	.546				
P	0.490	0.510		.503	.503				
Q	3.715	3.725		3.719	3.720				
R	2.470	2.510		2.490	2.496				
S	0.240	0.270		.251	.247				
T	0.100	0.180		.146	.146				
U	1.625	1.635		1.629	1.629				
V	1.362	1.372		1.366	1.366				
W	0.316	0.321		.326	.326				
X	1.125	1.145		1.135	1.135				
Y	1.565	1.585		1.574	1.574				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	08/08/30

Audited by:	<i>[Signature]</i>
Date:	08/08/30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
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